

Date: Wednesday, 1/10/2007 1:22:42 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACER
Job Number : 30226	
Estimate Number : 10683	
P.O. Number : <u>N/A</u>	Part Number : D34551
This Issue : 1/10/2007 S.O. No. : <u>N/A</u>	Drawing Number : D3455 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 28171	Material : <u>N/A</u>
Written By : <u>[Signature]</u>	Due Date : 1/17/2007 Qty: 50 Um: Each
Checked & Approved By : <u>[Signature] 07.01.10</u>	
Comment : EST REV A 05.11.17 NEW ISSUE EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MDELRLNR1000	Delrin Round Bar 1"
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Comment: Qty.: 0.0231 f(s)/Unit Total: 1.1550 f(s)
 Delrin Round Bar 1"
 (M-DELRIN-R1.000)
 Batch: 103164

S.F 07/01/12

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDHINGE COBRA
 1-TURN AS PER FOLIO FA583 & DWG D3455 ,
 FOLIO REV: SA
 DWG REV: A

2-DEBURR AS REQUIRED

SB 07/02/01 (46) S.F 07/01/12

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

S.F 07/01/12

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SG 07.01.15 46

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr if necessary.

SB 07/02/01 46

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LS Date: 07/02/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: SPACER

Job Number: 30226

Part Number: D34551

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Mo 7/02/06 (46)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

CP 04/02/06 (45)

CP 7/02/06

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(46)

Comment: FINAL INSPECTION/W/O RELEASE

07/02/07

Job Completion



U 07-02-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

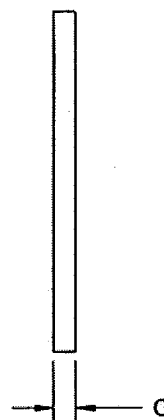
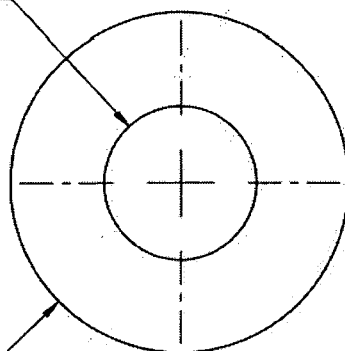
NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3455	REV. A SHEET 1 OF 1
DATE 05.09.02		TITLE SPACER	SCALE 2:1
A	05.09.02	NEW ISSUE	

RELEASED

05.12.09 [Signature]

 $\phi A^{+0.005}_{-0.000}$ ϕB **D3455-X**1) SPECIFICATION: **D3455-X SPACER**

DASH No.

WHERE 'X' IS THE SIZE PER THE FOLLOWING TABLE:

DASH No.	A (in)	B (in)	C (in)
-1	0.453	1.00	0.065
-3	0.386	1.00	0.050

NOTES:

- 1) MATERIAL: DELRIN ROUND BAR (REF. DART SPEC. M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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